

Work Order ID 101851

May-14-13 11:55:30 AM

101851

Page 1

Item ID: D2739

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 350 I Beam

Start Date: 5/14/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/21/13 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCS Date: 13-05-14 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev E

100	Skidtubes	0.00
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100

Skidtubes

Skidtubes

Memo

0.00

- 1-Cut D2600-5 to length as per Dwg D2739.
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

I.D. S.A.D. 13-05-15 (4)

120	Chemical Conversion Coat per QSI005 4.1	0.00
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120

HandFinish

Hand Finishing

Memo

0.00

I.D. S.A.D. 13-05-15 (4)

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Page 2

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Accept

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							
130						4	0	13-05-15	DAS 18 2-88
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>LG</u>	0.00							
140						3.0		13-05-15	
Packaging	Memo	0.00				5.0			
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150								13/5/15	
QC	Memo	0.00							
Quality Control									

MF
13-5-15

Picklist Print

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Page 1

Work Order ID: 101851

101851

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 5/14/13

Required Date: 5/21/13

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured No

Each

91.0000

D2600-5-108

Extrusion 'I Beam' thin

**

5.0 4
3.00

13-05-15

Location

Loc Qty

Loc Code

LG

91

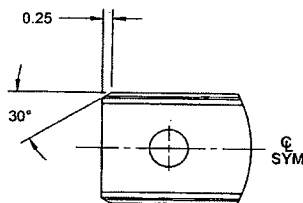
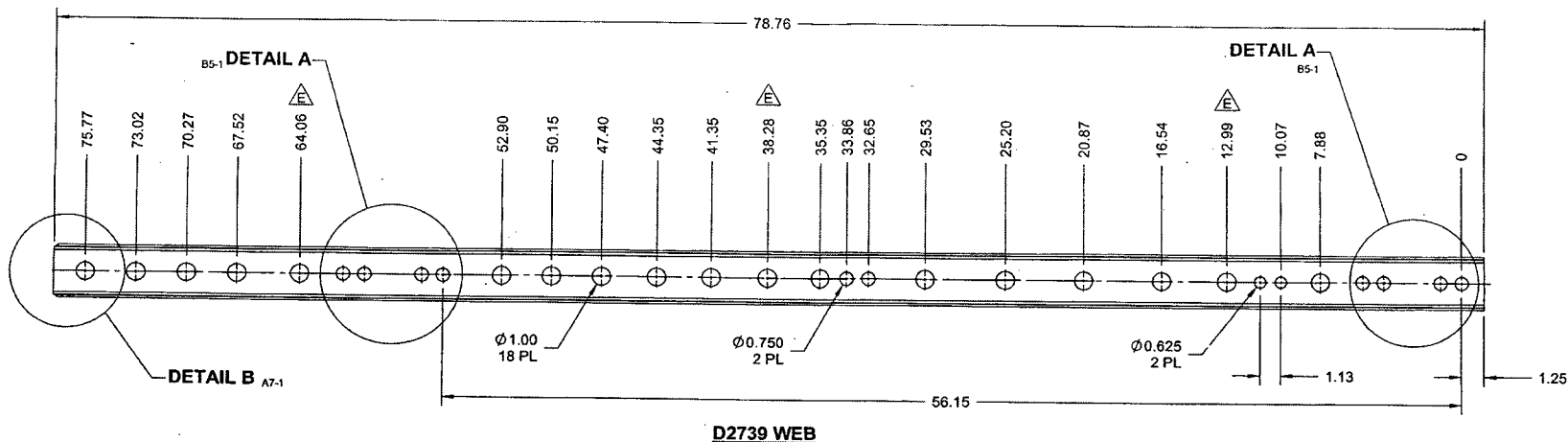
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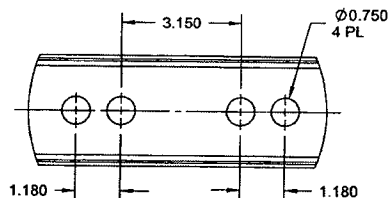
90684

89

4



DETAIL B
SCALE 3X



DETAIL A
SCALE 3X

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 3.41 lbs

SEE DRAWING
FOR ALL DIMENSIONS
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WATER ORDER
101851 MOW

13-05-14

RELEASED
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (DS-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRAUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2739 TITLE WEB SCALE NTS	
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JP		
APPROVED	JP		
DE APPR.	JP	REV. E SHEET 1 OF 1	
DATE	10.10.08		

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